

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021897**Date Inspected:** 12-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #19

Shielded Metal Arc Welding (SMAW)

Weld joint- 004 Located on Suspender Bracket SB 023-106 as per CWR no. B-CWR-2779. Welder is identified as 259566. ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

Bay #16

Flux Cored Arc Welding (FCAW)

Weld joint 126 Located on Crash Barrier W5-SB31-002. Welder is identified as 201879. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 019 Located on Crash Barrier W5-SB25A. Welder is identified as 062092. ZPMC Quality Control

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Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131-ESAB.

Weld joint- 019, Located on Crash Barrier W2-SB27-005. Welder is identified as 201074. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131-ESAB.

Weld joint- 126 Located on Crash Barrier E2-SB35. Welder is identified as 222396. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

### Shielded Metal Arc Welding (SMAW)

Weld joint- 51 Located on Crash Barrier W5-SB41A-001. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Bay #14

This QA Inspector observed the following work in progress

### Flux Cored Arc Welding (FCAW)

Weld joint-119, Located on I rib to Bottom plate in Segment 14W, SEG 3020L. Welder is identified as 066239. ZPMC Quality Control Inspector (QC) is identified as Sun Lian Tiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB

Weld joint-089, Located on I rib to Bottom plate in Segment 14W, SEG 3020H. Welder is identified as 204730. ZPMC Quality Control Inspector (QC) is identified as Sun Lian Tiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB

### Shielded Metal Arc Welding (SMAW)

Weld joint-176, Located on Floor beam to I rib, SEG 3020L in Segment 14W. Welder is identified as 067572. ZPMC Quality Control Inspector (QC) is identified as Sun Lian Tiang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-FCM-1.

### Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No.

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08529

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Lift 14 and 13W Components. The weld designation reviewed as follows:

SEG 3020BB – Jt. nos. -064, 028

SEG 3020X – Jt. nos. -10, 11, 13, 14

SEG 3020Z – Jt. nos. -071, 030, 033

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer